

Sept 12

Dart Aerospace Ltd.

Date: Tuesday, 15/08/2006 7:19:47 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STOP
Job Number	: 28183	Part Number	: D28054
Estimate Number	: 10516	Drawing Number	: D2805 REV. B
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 15/08/2006 S.O. No. : N/A	Drawing Revision	: B
Prsh Rev.	: NC	Material	: N/A
First Issue	: N/A	Due Date	: 08/09/2006 Qty: 20 Um: Each
Previous Run	: N/A		
Written By	:		
Checked & Approved By	:		
Comment	: Est: A 01.03.21 New Issue EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6B1500X01500	6061-T6 Bar 1.5" x 1.5"	
		Comment: Qty.: 0.2756 f(s)/Unit Total : 5.5125 f(s) 6061-T6 Bar 1.5" x 1.5" Material: 6061-T6 (QQ-A-200/8 or QQ-A-250/11) 1.5" x 1.5" (M6061T6B1500X01500)	M16954 X 16 Batch: M18147 X 4
2.0	BAND SAW	BAND SAW	
		Comment: BAND SAW Cut Bar: 3.150" Long +0.010/-0.030"	J.G 06/08/16
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 1- Machine as per Folio FA104 and Dwg D2805 2- Tumble and Deburr Identify as D2805-5	PTU J.G 06/08/19 20
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	J.G 06/08/19 20
5.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	J.L 06/08/20 20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 06.08.21
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/08/19	3	1 piece move in the vice.		destroy and replace	ml 06/08/26	 	 	 

NOTE: Date & initial all entries

Date: Tuesday, 15/08/2006 7:19:47 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STOP

Job Number: 28183

Part Number: D28054

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

a.m 06-08-22

(20)

7.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT ALODINE

SL 06/08/23

(23)

8.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST387

SL 06/08/23

(20)

9.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Inspection Level 21

A 06.08.24

Job Completion



U 06.08.23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

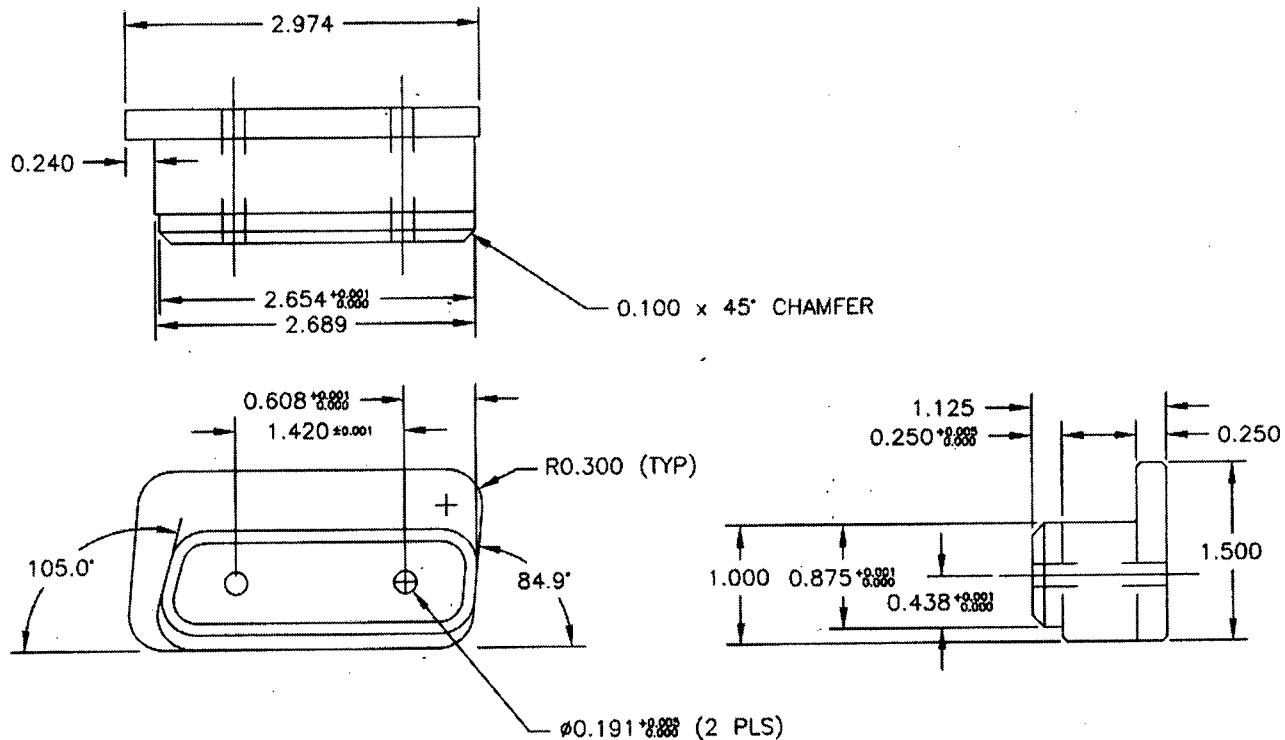
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
		D2805	SHEET 1 OF 2
DATE		TITLE	SCALE
01.03.13		STOP	2:3
A	00.10.31	NEW ISSUE	
B	01.03.13	ADD -3/-4	

RELEASED
 01.03.16 *f*

D2805-1 (SHOWN)
D2805-2 (OPPOSITE)
REFERENCE ONLY

BREAK ALL OUTSIDE EDGES 0.030 TO 0.060 UNLESS OTHERWISE NOTED.
 BREAK ALL INSIDE EDGES 0.005 TO 0.015 UNLESS OTHERWISE NOTED.

MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11)

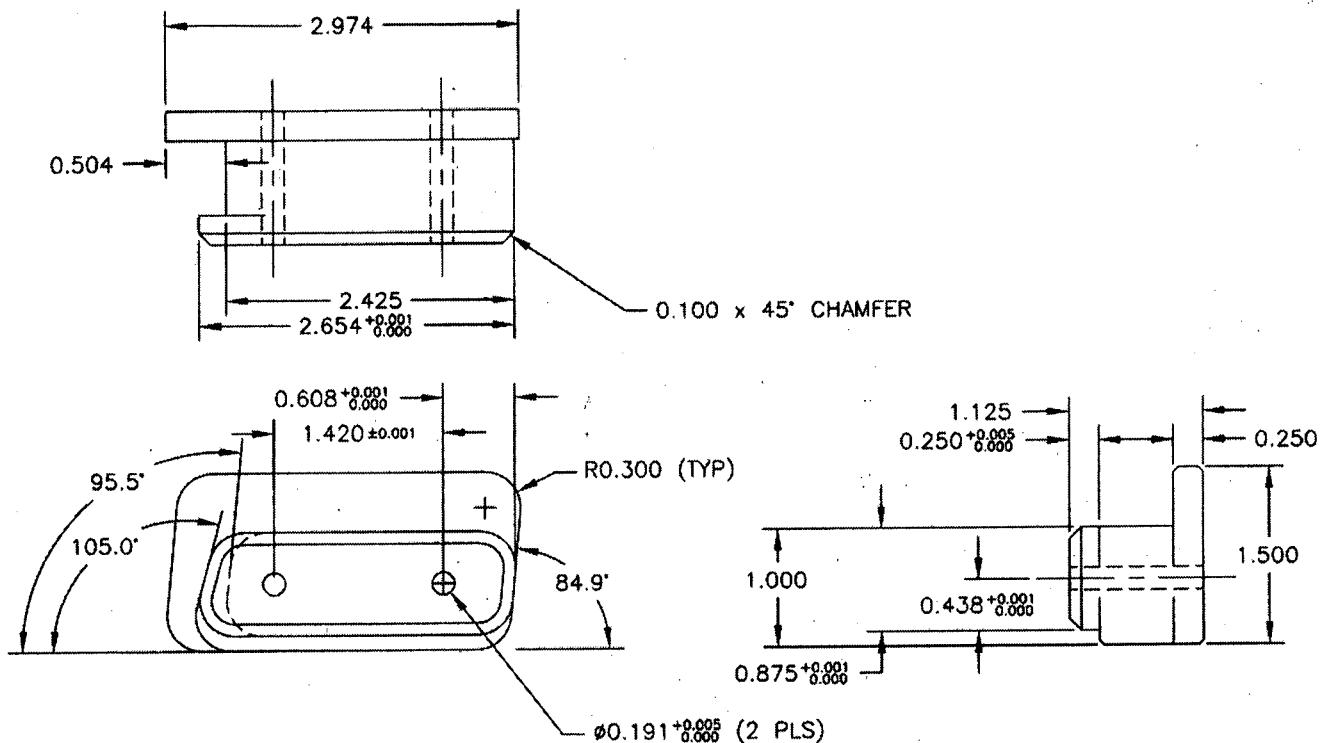
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 .4.1
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DART

DESIGN	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2805
DATE		REV. B SHEET 2 OF 2 TITLE STOP SCALE 2:3

RELEASED
01.03.16 *CP*

D2805-3 (SHOWN)
D2805-4 (OPPOSITE)

BREAK ALL OUTSIDE EDGES 0.030 TO 0.060 UNLESS OTHERWISE NOTED.
BREAK ALL INSIDE EDGES 0.005 TO 0.015 UNLESS OTHERWISE NOTED.

MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11)

FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DART AEROSPACE LTD	Work Order:	
Description: Stop	Part Number:	D2805-4
Inspection Dwg: D2805	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article

Measured by:	J-F.	Audited by:	mk	Prototype Approval:	N/A
Date:	06/08/18	Date:	06/08/19	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.10.05	New Issue	KJ/JLM	